

Date: Thursday, 01/05/2008 9:45:54 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 38921		
Estimate Number	: 10531		
P.O. Number	:	Part Number	: D2572
This Issue	: 01/05/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2572 REV E
First Issue	: / /	Project Number	: N/A
Previous Run	: 38654	Drawing Revision	: E
	Type	Material	:
	: MACHINED PARTS	Due Date	: 10/05/2008
Written By	:	Qty:	8 Um: Each
Checked & Approved By	: <u>JLW 08.5.01</u>		
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 7075-T7351 8.25X5.0X2.5
 Make from D6101-005 billet for D2572
 Ensure that grain is along 5.00" length
 Batch No: B34374

SF 08/05/07

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. SF Double check by: _____

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove shap edges.

SF 08/05/07

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2571 & D2572

SF 08/05/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 9:45:54 AM
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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 38921

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

2/08/05/05

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 08/05/14

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

W/BK 08-05-20

(8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

11:15am

OVEN TEMPERATURE:

320°F

FINISH TIME:

11:45am

M-L 08/05/20

(8X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FX 08/05/20 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5432

08/05/20 (8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF 08-05-22

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 38921
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.443	0.443	0.443	0.441		
B	1.745	1.755		1.749	1.750	1.750	1.750		
C	3.495	3.505		3.499	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.749	1.750	1.7500		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		0.506	0.495	0.500	0.499		
G	0.257	0.262		0.259	0.259	0.259	0.259		
H	0.375	0.380		0.378	0.378	0.378	0.378		
I	0.490	0.510		0.502	0.508	0.502	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.177		
K	0.558	0.578		0.5705	0.5705	0.570	0.5715		
L	1.174	1.184		1.179	1.179	1.180	1.180		
M	1.490	1.500		1.495	1.495	1.493	1.493		
N	2.495	2.505		2.500	2.500	2.500	2.499		
O	3.869	3.879		3.874	3.874	3.874	3.876		
P	0.115	0.135		0.123	0.123	0.124	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.248	0.248	0.250	0.250		
S	0.115	0.135		0.122	0.122	0.122	0.1235		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.958		
V	0.230	0.250		0.230	0.230	0.237	0.232		
W	0.115	0.135		0.126	0.121	0.124	0.124		
X	0.307	0.312		0.309	0.309	0.309	0.309		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.364	0.362	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.626	0.626	0.625		
AC	0.053	0.073		0.0625	0.0625	0.063	0.063		
AD	0.240	0.260		0.243	0.243	0.242	0.243		
AE	1.375	1.395		1.3885	1.3885	1.3915	1.391		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.243	0.244	0.245	0.250		
AI	2.000	2.020		2.003	2.003	2.009	2.0085		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: JIP
Date: 08/05/10

Audited by: JI
Date: 08/05/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 38921
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	Date
A	0.438	0.443		.441	.441	.442	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.001	8.001	8.002		
F	0.490	0.510		.505	.500	.505	.505		
G	0.257	0.262		0.259	0.259	.259	.258		
H	0.375	0.380		0.378	0.378	.378	.375		
I	0.490	0.510		.505	.501	.505	.505		
J	1.174	1.184		1.179	1.177	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.499	1.499	1.500	1.495		
N	2.495	2.505		2.498	2.499	2.500	2.500		
O	3.869	3.879		3.873	3.874	3.874	3.874		
P	0.115	0.135		0.124	0.125	.122	.122		
Q	0.115	0.135		0.135	0.135	.135	.135		
R	0.240	0.260		0.256	0.257	.258	.258		
S	0.115	0.135		.122	.125	.125	.115		
T	0.178	0.198		0.188	0.188	.188	.188		
U	2.940	2.980		2.958	2.959	2.960	2.960		
V	0.230	0.250		.243	.240	.240	.240		
W	0.115	0.135		.125	.125	.125	.120		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.362	.362	.358		
AA	0.470	0.530		0.500	0.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.620		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.385	1.385	1.385	1.389		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		0.260	0.260	.260	.260		
AH	0.240	0.260		.250	.250	.250	.249		
AI	2.000	2.020		2.002	2.001	2.001	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

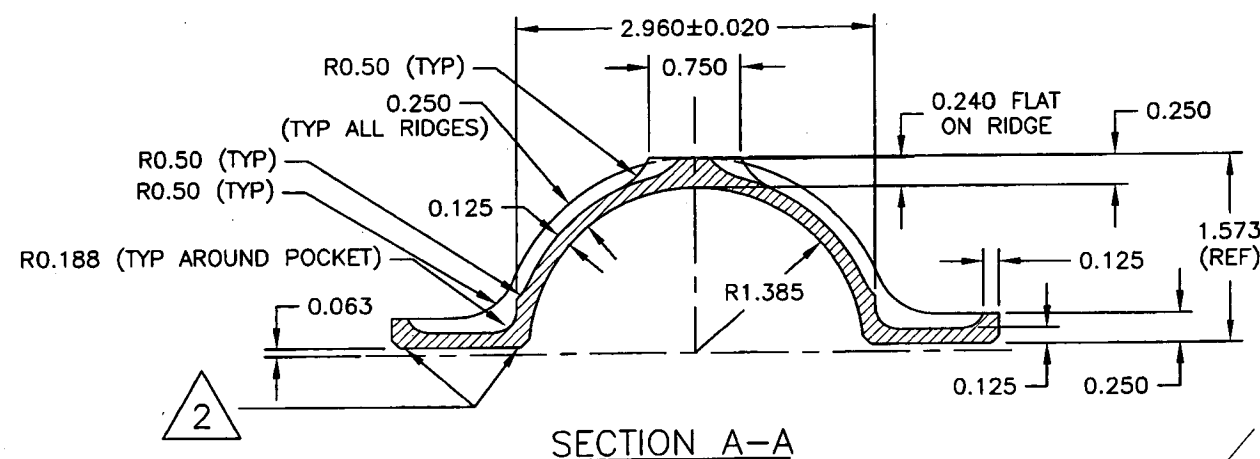
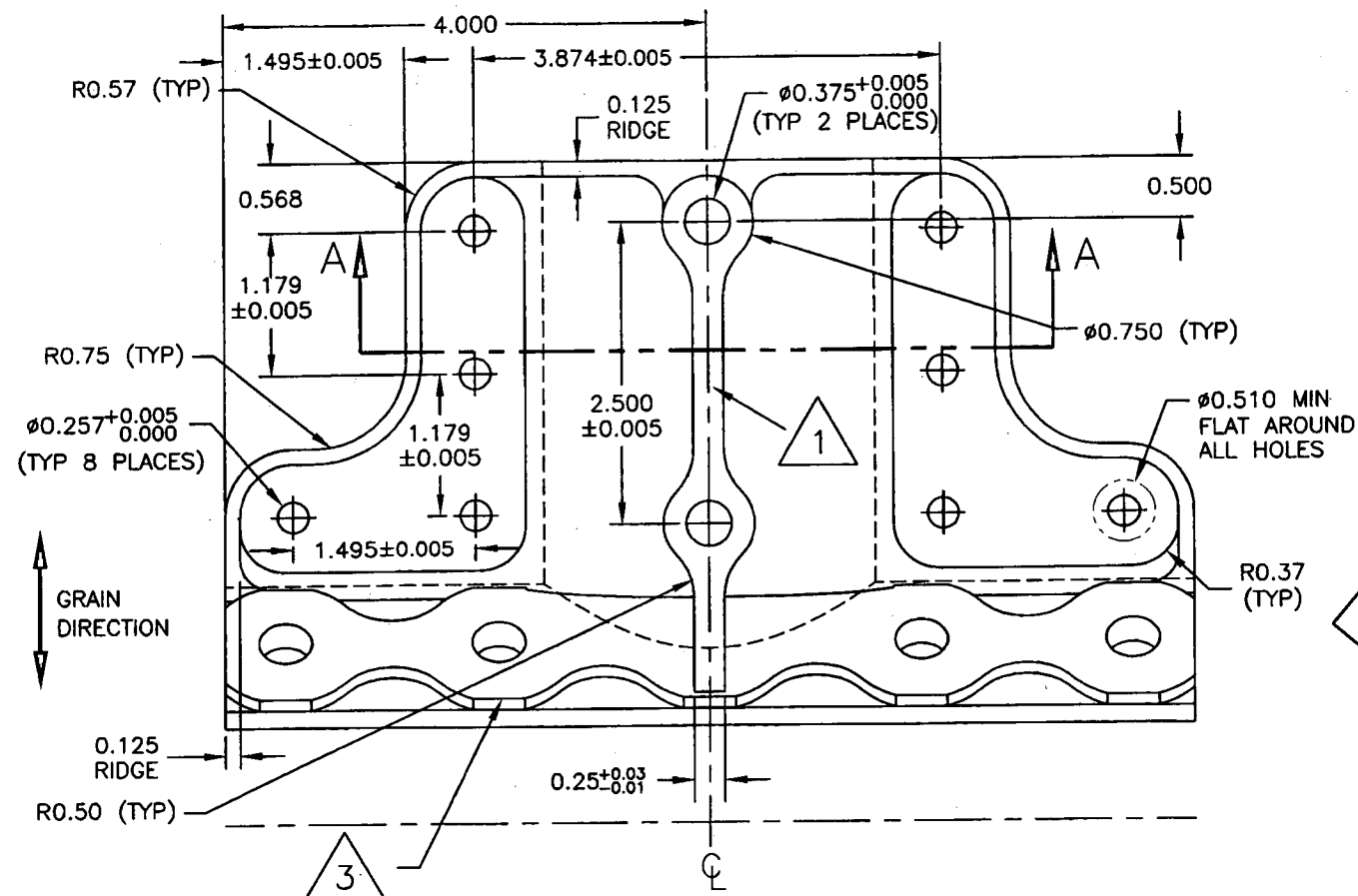
Measured by: DTP
Date: 08/05/12

Audited by: JL
Date: 08/05/14

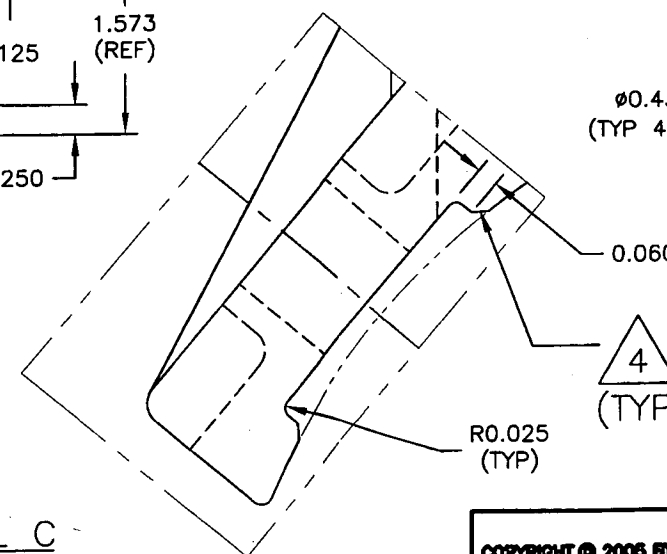
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

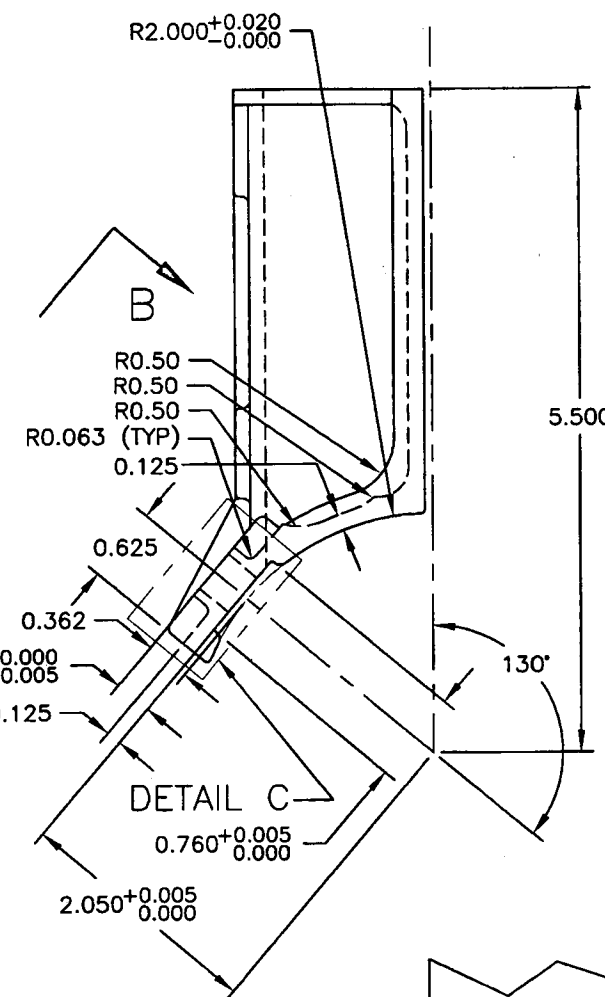
05.12.06



SECTION A-A



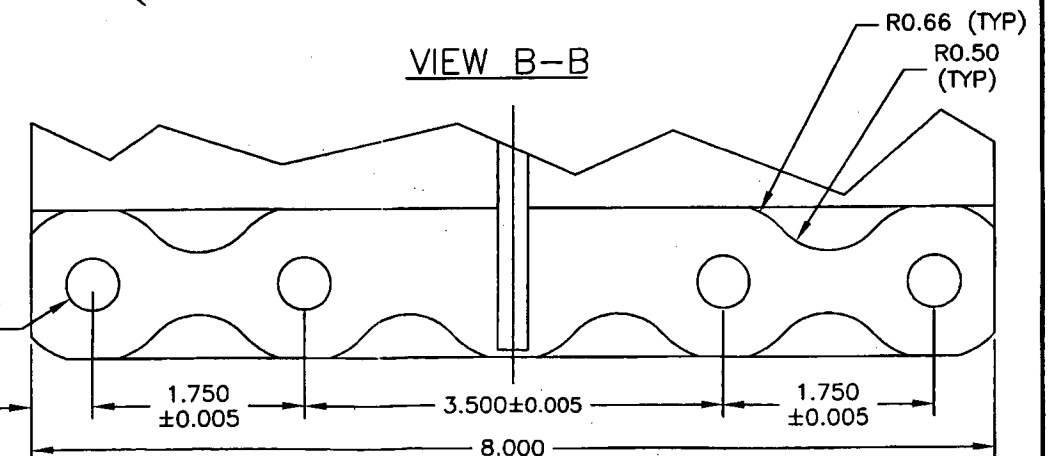
DETAIL C
SCALE 2:1



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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DESIGN DS	DRAWN BY PH	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D2572	REV. E SHEET 1 OF 1
DATE 05.07.13	TITLE INNER FWD SADDLE	SCALE 2:3	

